

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012710**Date Inspected:** 18-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

7AE

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 007 located at SEG034A bike path side of segment. Welder is identified as Mr. Dai Lu (048659). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-1G (1F)-FCM-Repair-1 and CWR1211 repair procedure.

Y Location of repairs areas by above noted welder (048659) is located at 85mm~1305mm.

7BW+7CW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 010 located at OBW7 cross beam side of segment. Welder is identified as Mr. Yun Chuansheng (045221). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2113-B-U2-FCM-1.

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7CW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 004 located at CA037 counter weight side of segment. Welder is identified as Mr. Tang Yongqing (066028). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 004 located at CA037 counter weight side of segment. Welder is identified as Mr. Duan Yanyang (066422). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair-1 and CWR1228 repair procedure.

7BE+7CE

Shield Metal Arc Welding (SMAW) repair welding was performed on base metal at bottom plate and side plate bike path and cross beam side of segment. Welder is identified as Mr. Hu Yanming (062092). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-Repair-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 008 located at OBW7B bottom plate splice of segment. Welder is identified as Mr. Feng Changdou (067572). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-B-U2-FCM-1.

7CE

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 004 located at CA040 on the bike path side of segment. Welder is identified as Mr. Chen Renzhi (058087). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-1 and CWR1227 repair procedure.

Y Location of repairs areas by above noted welder (058087) is located at 11060mm~11810mm.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 004 located at CA040 Bike Path side of segment. Welder is identified as Mr. Sun Lingling (048047). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2114-FCM-1.

Y Location of repairs areas by above noted welder (048047) is located at 7470mm~6770mm.

Miscellaneous Work In Progress

QA Inspector observed ZPMC's personnel performing various job functions in the trial assembly yard. Locations and description of work are as followed:

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6 West

1. Coating in progress of external areas on cross beam and counter weight side of segment.

NDT Observation

This QA Inspector observed ZPMC Magnetic Particle Testing (MT) Technician performed MT on various locations in the trial assembly yard. Locations are as followed:

7CW

1. Performed on weld joint CA037-004 at counter weight side of segment.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (150-0042-2372), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
